

Work Order ID 79906

February-07-12 10:06:15 AM

Now

\*79906\*

Page 1

Item ID: D4406-043

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Aft Wearplate Assembly

Start Date: 2/07/12 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 2/08/12 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4406

pb1 A 12.02.10

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg D4406-3

prog rev: A

dwg rev: A

2-Deburr if required

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

W 12.02.07 (4)

W 12.02.07 (4)

# Work Order ID 79906

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Item ID: D4406-043  
Revision ID:  
Item Name: Aft Wearplate Assembly

Start Date: 2/07/12 Start Qty: 4.00  
Required Date: 2/08/12 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: Date:  
QC: Date:

Sequence ID/ Work Center ID	Operation Description
180	QC5- Inspect part completeness to
<b>*180*</b>	
QC	Memo
Quality Control	

190	Identify as per dwg & Stock Local
<b>*190*</b>	
Packaging	Memo
Packaging	

200	QC21- Final Inspection - Work Or
<b>*200*</b>	
QC	Memo
Quality Control	

# Work Order ID 79906

February-07-12 10:06:15 AM

Item ID: D4406-043  
Revision ID:  
Item Name: Aft Wearplate Assembly

Start Date: 2/07/12 Start Qty: 4.00  
Required Date: 2/08/12 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
150		0.00
<b>*150*</b>		
Large Fab	Memo	0.00
Large Fab	Weld bar as per dwg A/R 2059b hardcoat Batch#: <u>M120480</u>	
	Weld bar to wearplate as per dwg A/R s.s. rod Batch #: <u>M118367</u>	

160	<del>QC10</del> Inspect visual per QS1004- ground welds	0.00
<b>*160*</b>		
QC	Memo	0.00
Quality Control		

170		0.00
<b>*170*</b>		
Small Fab	Memo	0.00
Small Fab	Apply coating as per dwg D4406	

B120579

**\*79906\***

Page 3

Accept **\*N9000040100\*** Setup Start **\*NS1\***  
Stop **\*NS2\***

Cust Item ID:  
Customer:

Run Start **\*NR1\***  
Stop **\*NR2\***

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

X4 12-02-09 JBL

PL 12.02.09

4x

8.26.09

(74)

A3 12 - 2 - 9 (4)

# Picklist Print

February-07-12 10:06:14 AM

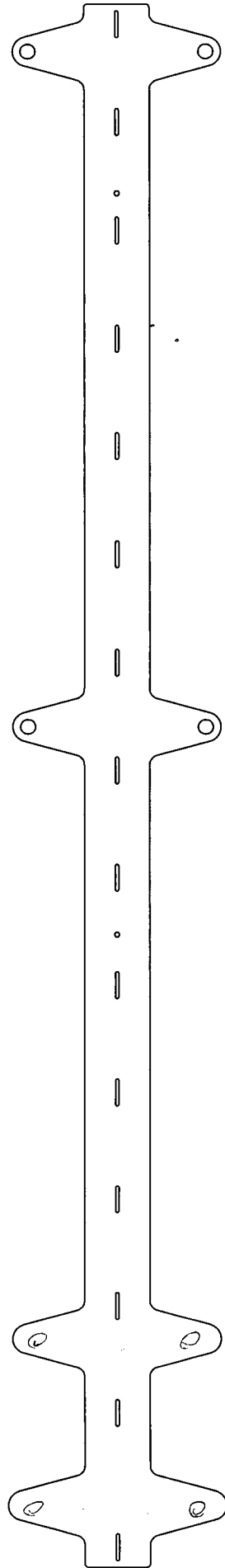
Page 1  
T

Work Order ID: 79906  
Parent Item: D4406-043  
Parent Item Name: Aft Wearplate Assembly


Start Date: 2/07/12  
Start Qty: 4.00  
Required Date: 2/08/12  
Required Qty: 4.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD  
revPB1 DD verf:EC  
IPP rev B 12.02.06 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-3 Bar		Manufactured	No			150	Each	10.0000	2	8		12-02-09	
		79074X4		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	356.5050	2.92	12.294737		12-02-07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		356.505							
				119032		17.3							
				119383		96							
				119766		34.705							
				120243		208.5							



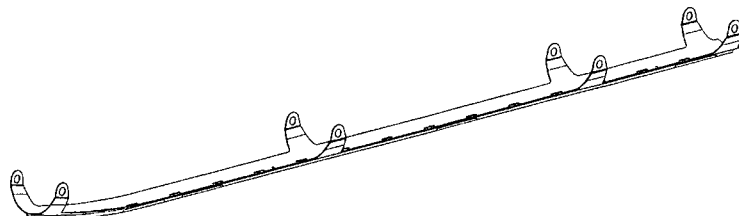
04406-3F Modify FLAT PATTERN (REV. A)  
DATED 12/02/01 BY RF

Measured by:		Date:	12-02-07
Audited by:	S	Date:	12/02/07
Prototype Approval:		Date:	

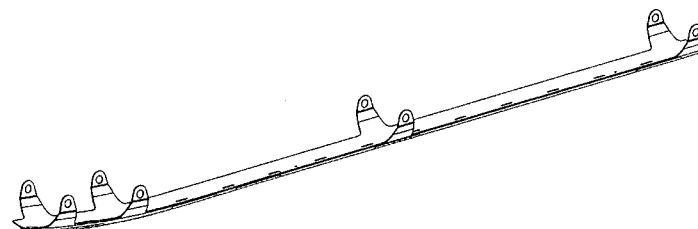
Drawing	Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.17		+/-0.030	8.17	✓		M.T	HB-01
7.77		+/-0.030	7.77	✓		M.T	" "
24.995		+/-0.010	24.995	✓		M.T	" "
7.203		+/-0.010	7.203	✓		VWN	Rad-W-5-02
58.12		+/-0.030	58.12	✓		M.T	HB-01
27.50		+/-0.030	27.50	✓		M.T	HB-01
7.00		+/-0.030	7.00	✓		M.T	HB-01
3.63		+/-0.030	3.63	✓		M.T	HB-01
7.78		+/-0.030	7.78	✓		M.T	HB-01

☒ First Article     ☒ Prototype  
 FIRST ARTICLE INSPECTION CHECKLIST

79906	Work Order:		
D4106-043	Part Number:		
Description: Aft Wreplate Assembly			
Inspection Dwg: D4106		Rev: A	
Page 1 of 1			



**D4406-041 FWD WEARPLATE ASSY**



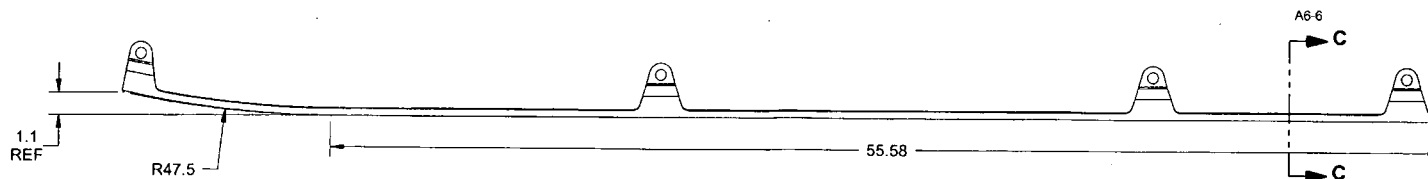
**D4406-043 AFT WEARPLATE ASSY**

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)

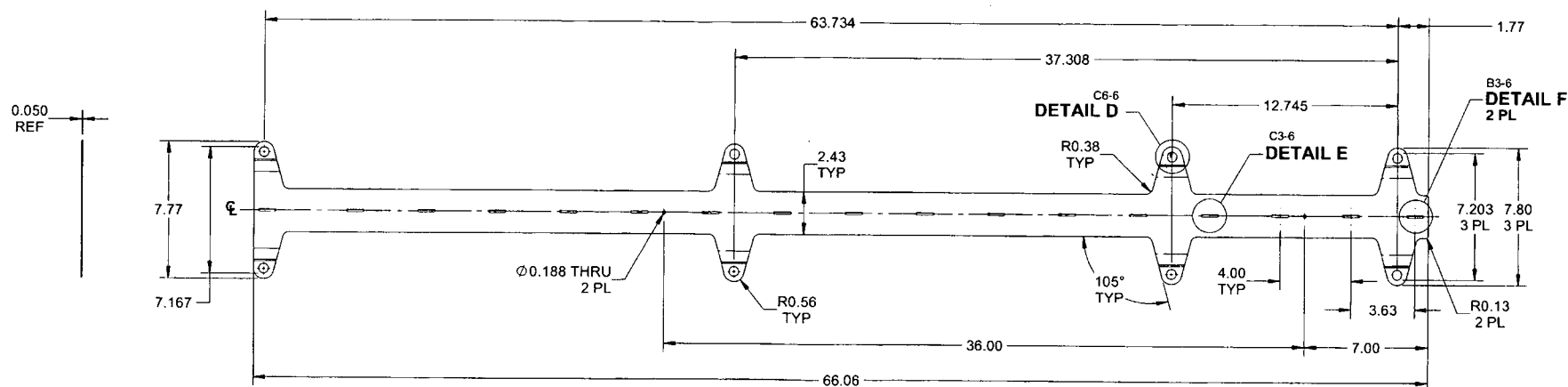
1079906

RELEASED  
2011-08-29

A	NEW ISSUE		RF	11.08.15
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	10	DRAWING NO.	REV. A	
MFG. APPR.	10	D4406	SHEET 1 OF 6	
APPROVED	10	TITLE	SCALE	
DE APPR.	10	WEARPLATE ASSY	NTS	
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**D4406-1 PLATE**  
(MAKE FROM D4406-1F)



**D4406-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

**RELEASED**  
2011-08-28  
JW

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4406</b>	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>WEARPLATE ASSY</b>	NTS
DATE	11.08.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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A6-6

C

1.4  
REF

45.0

R62.7

**D4406-3 PLATE**  
(MAKE FROM D4406-3F)

54.053

47.833

C3-6  
**DETAIL E**C6-6  
**DETAIL D**0.050  
REF

1.76

7.77  
2 PL7.203  
2 PL

24.995

 $\varnothing 0.188$  THRU  
2 PL4.00  
TYPR0.13  
TYP

3.63

7.00

R0.55  
TYP105°  
TYP

27.50

58.12

R0.38  
TYP

7.133

7.78

2.43  
TYP

7.567

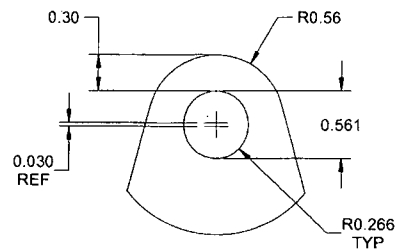
8.17

B3-6  
**DETAIL F**  
2 PL**D4406-3F FLAT PATTERN****RELEASED**  
2011-08-29  
MD**NOTES:**

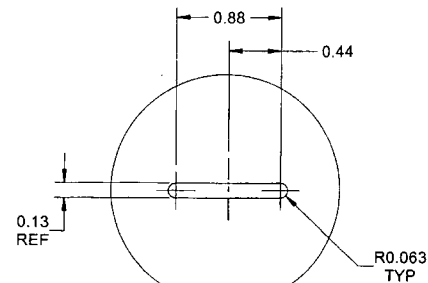
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4406	SHEET 5 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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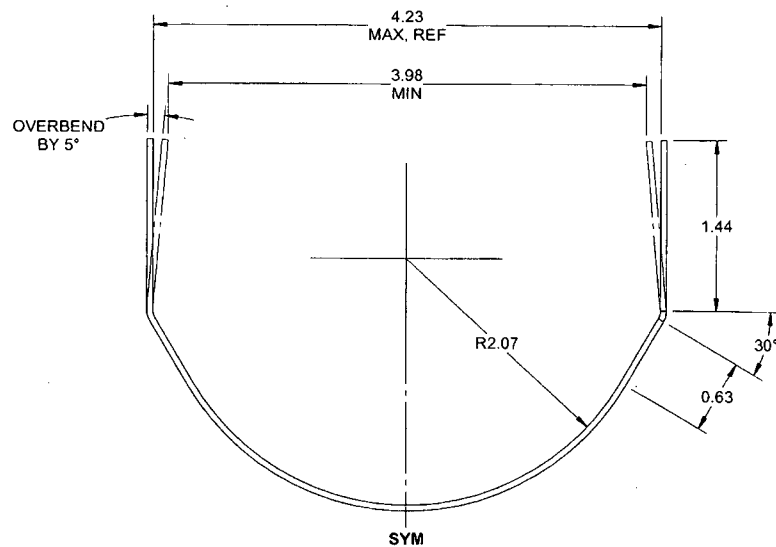




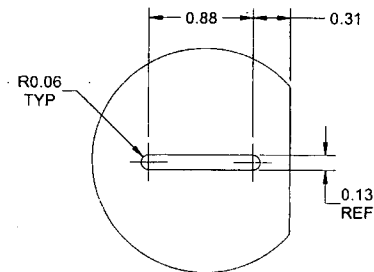
**DETAIL D**  
SLOT DETAIL TYP  
SCALE 6X  
C3-4  
C4-5



**DETAIL E**  
SLOT DETAIL TYP  
SCALE 6X  
C2-4  
C4-5



**DETAIL C**  
DETAIL TYP  
SCALE 6X  
D2-4  
D8-5



**DETAIL F**  
SLOT DETAIL TYP  
SCALE 6X  
C1-4  
B1-5

**RELEASED**  
2011-08-29  
JW

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>140</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>140</i>	<b>D4406</b>	SHEET 6 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	<b>WEARPLATE ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.02.10	100	Holes not drilled in two sets of aft tabs.	GP 12.02.10 OSIDR	Drilled to fit skeltube during assembly Acceptable	GP 12.02.10		GP 12.02.10 PSIDR	

NOTE: Date & initial all entries